

Work Order ID 82248

82248

Page 1

March-27-12 2:20:24 PM

Item ID: D3592-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plate
 Start Date: 27/03/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 10/04/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3592	Rev B								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet

1-Cut as per Dwg D3592
 *****ENSURE GRAIN IS AT 45 DEG AS PER DEO D3592-b-1*****
 Dwg Rev: B
 Prog Rev: B
 2-Debur if necessary

W 12.03.27 (40)

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

W 12.03.28 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				count 40			
130 *130* Small Fab Small Fab	Small Fab Memo Form as per Dwg D3592 using DT8949	0.00 0.00				40			Sh 12/08/29
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				40 count			DAS 16 9-89 17/08/30

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Page 3

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>W14</u>	0.00				<u>40</u>	<u>0</u>		<u>12-08-30</u>
150									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 12 10 08 130

MF
12-08-30

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Picklist Print

March-27-12 2:20:28 PM

Page 1

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82248

Parent Item: D3592-1

D3592-1

Parent Item Name: Plate

Start Date: 27/03/2012

Required Date: 10/04/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-03.26 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	82.2900	0.139	5.852632			
M6061T6S 125									**	w 12.03.27			
6061-T6.125 Sheet													

M6061T6S 125

6061-T6 .125 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	82.29	
113608	46.69	
118217	0.09	
119513	10.8	
120218	24.71	

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Dart Aerospace Ltd

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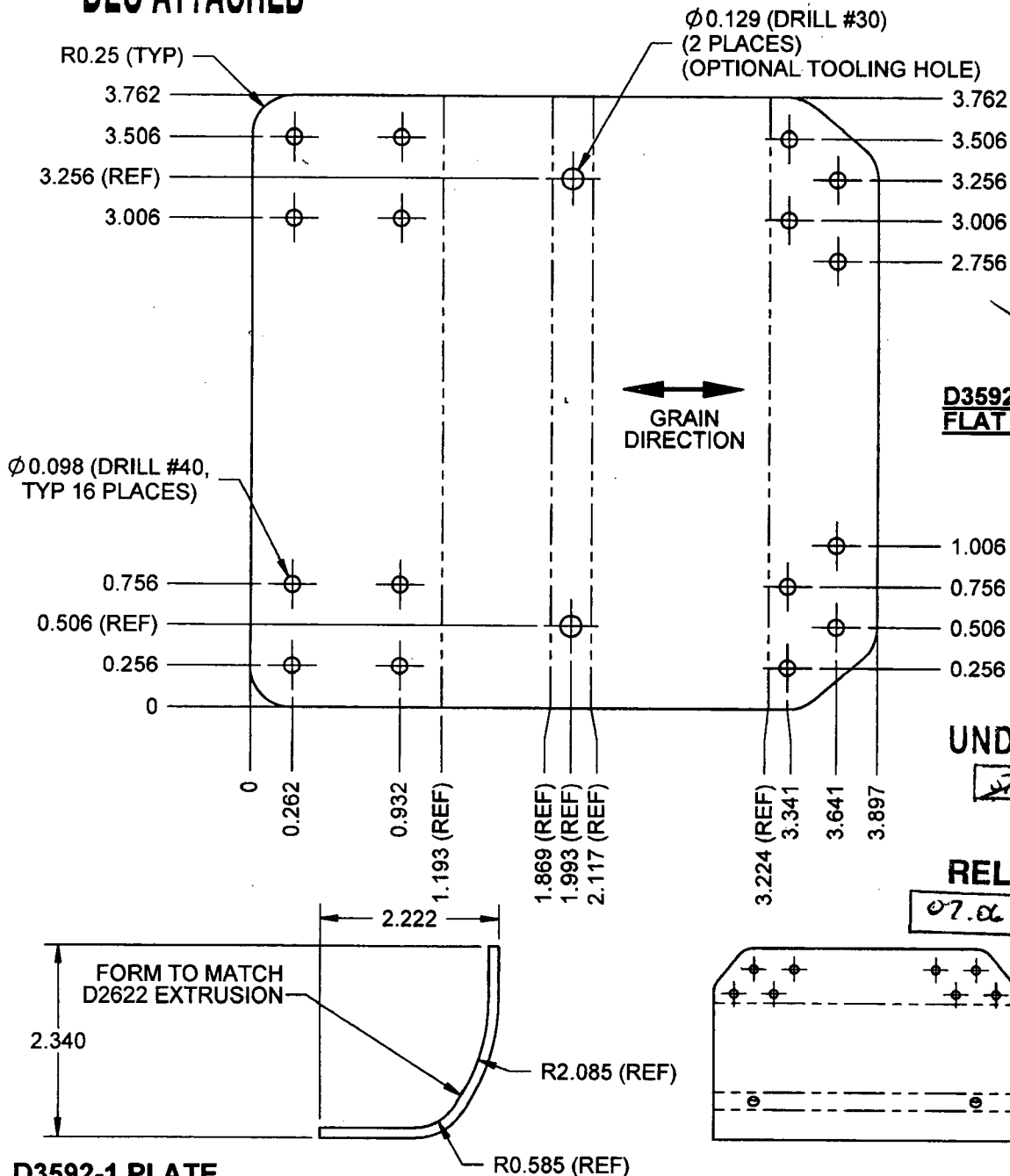
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DART

DESIGN <i>qp</i>	DRAWN BY <i>DL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>qp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3592	REV. B SHEET 1 OF 1
DATE 07.05.31		TITLE PLATE	SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

DEO ATTACHED**D3592-1F
FLAT PATTERN****UNDER REVIEW****RELEASED****BEND DETAIL
SCALE 1:2****D3592-1 PLATE****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

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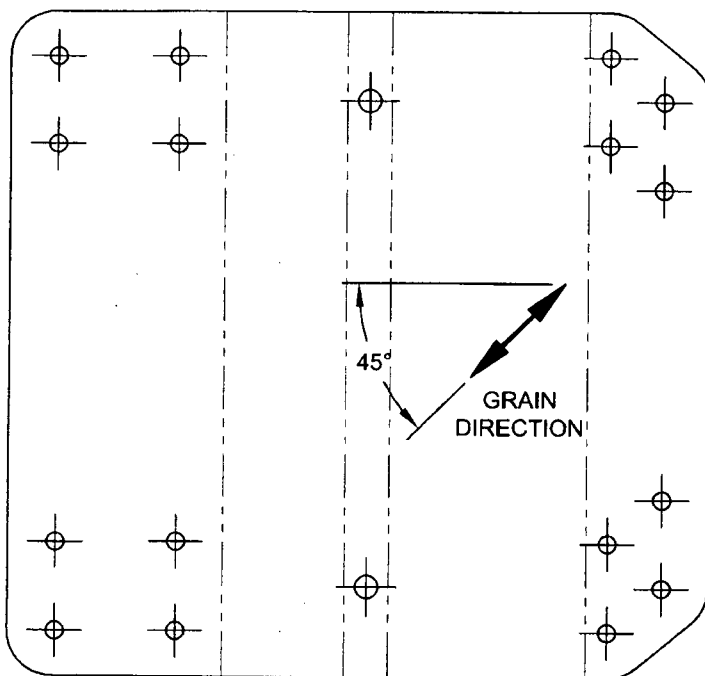
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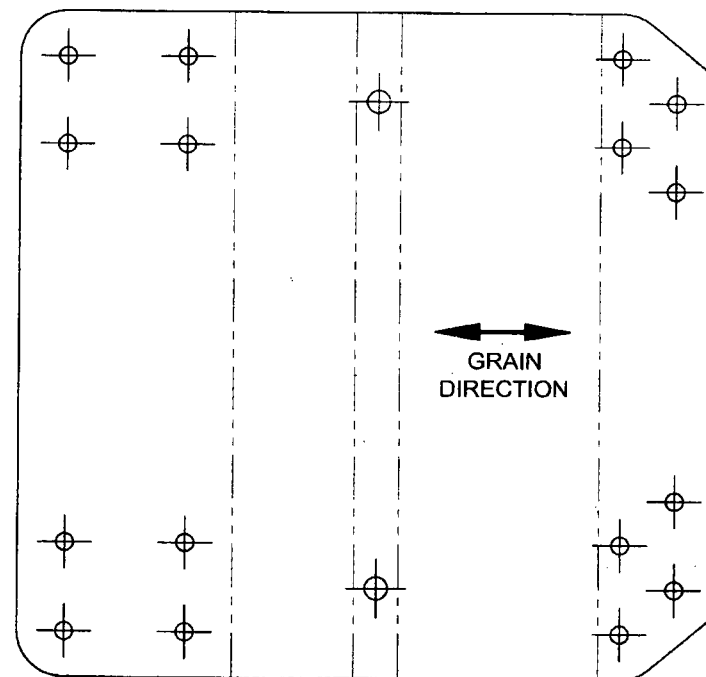
DRAWING NO. D3592	TITLE PLATE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3592-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>l</i>	MFG. APPR. <i>AD</i>	APPROVED <i>W/P</i>		DE APPR. <i>M</i>		
DATE 08.09.11	DATE 08.09.11	DATE 08/09/11	DATE 08/09/11		DATE 08/09/11		

MODIFY GRAIN DIRECTION AS SHOWN BELOW TO PREVENT CRACKING WHEN WELDING AT ASSEMBLY (SEE CAR 08-026).

IS:



WAS:



82248

ALL OTHER INFORMATION REMAINS UNCHANGED

RELEASED
08.09.11

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